

Work Order ID 71654 -1

Thursday, July 07, 2011 12:06:35 PM



Page 1

Item ID: D3256-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel

Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CY Date: 11/07/07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3256

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3256

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

BI-8-10

7

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

BI-8-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/11

47

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71654

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Item ID: D3256-1

Accept



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Revision ID:

Stop



Item Name: Panel

Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE Memo Form using D3256-1T2	0.00 0.00				<i>JS.</i>	<i>①</i>		
140 QC	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	<i>S</i>			<i>12/02/10</i>	<i>(H)</i>		
150 Packaging	Identify as per dwg & Stock Location: <i>17B</i> Memo	0.00 0.00				<i>10/2/10</i>	<i>S</i>	<i>②</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71654

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Page 3

Item ID: D3256-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel

Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/2/13 *[Signature]**ME*
12-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:06:33 PM

Page 1

Work Order ID: 71654

Parent Item: D3256-1

Parent Item Name: Panel



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-28 EC verified by:DD
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S22GA

Purchased

No

100

sf

43,3600

0.987

6,233,684

7.



1811-8-10

304/316 .032 Sheet

Location

Loc Qty

Loc Code

020

5.8

109057

5.8

MAT020

37.56

117379

37.56

118400

118400

A

WORK ORDER CHANGES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

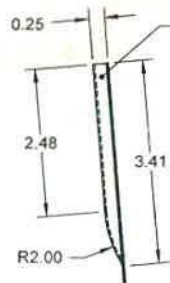
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

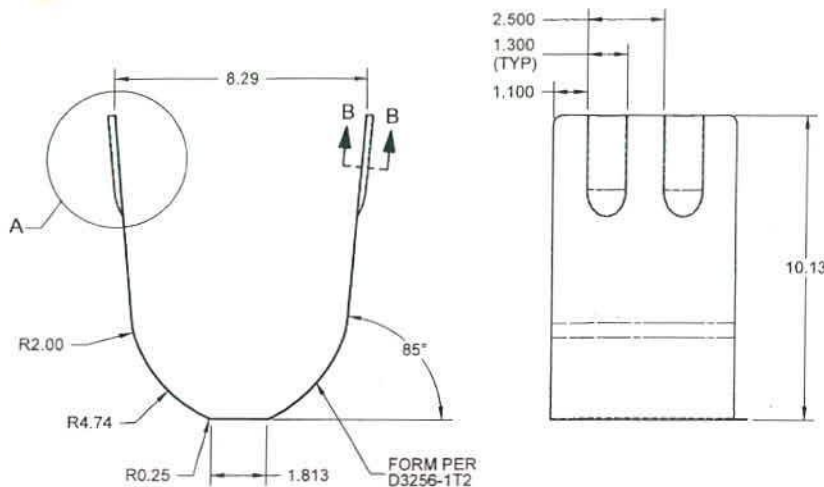
WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

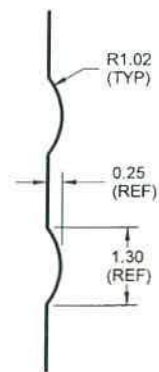
NOTE: Date & initial all entries



DETAIL A
SCALE 1:2



D3256-1 ACCESS PANEL
(MAKE FROM D3256-1F)

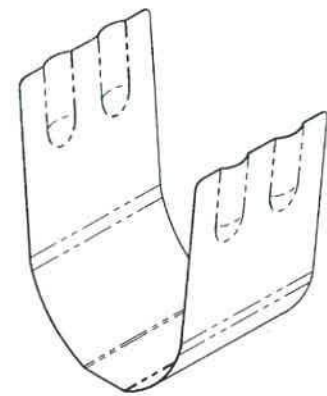


SECTION B-B
SCALE 1:2
(VIEW ROTATED)

RELEASED
107.10.23

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF, DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.37 lbs

D3256-1F FLAT PATTERN Δ



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71654
C21110710

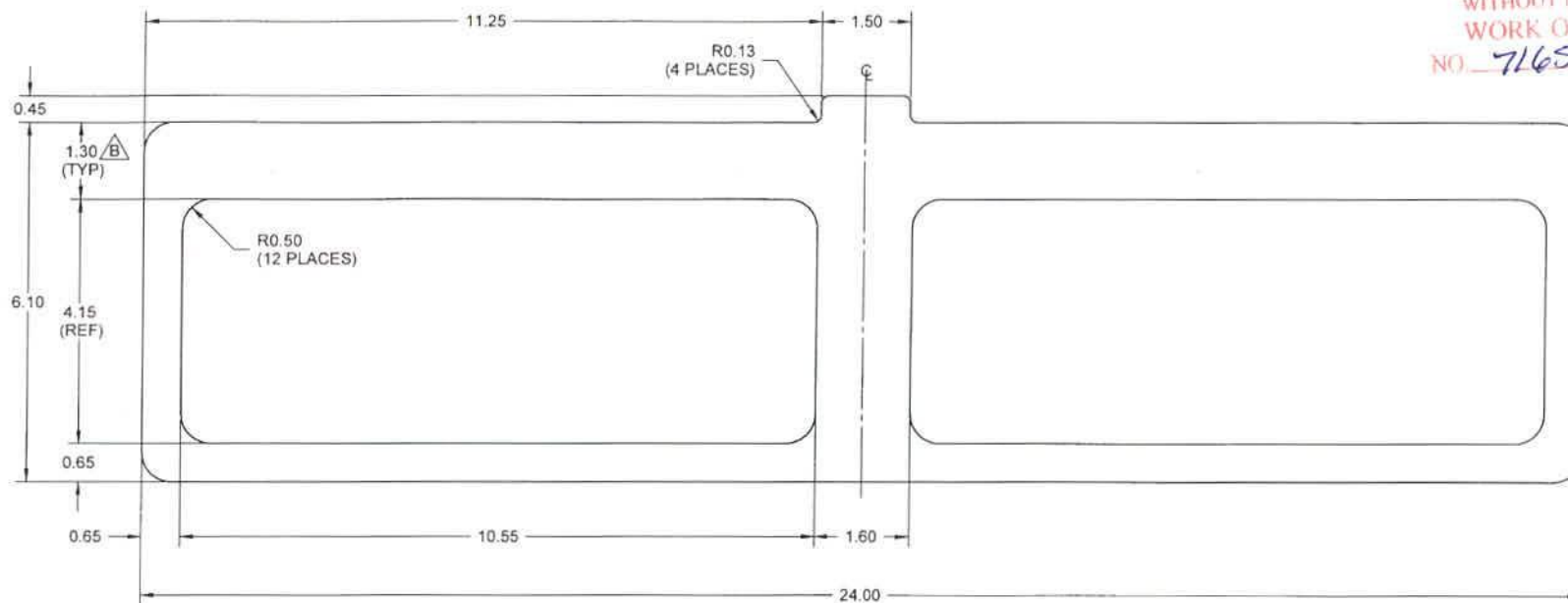
C	D3256-041 ELIMINATED: REMOVED (QTY.22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TH		
DRAWN	TH		
CHECKED	PH		
MFG. APPR.	DS		
APPROVED	TH		
DE APPR.	TH		
DATE	07.09.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3256** REV. C
SHEET 1 OF 2
TITLE **ACCESS PANEL** SCALE 1:4

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WITHOUT NOTICE
WORK ORDER
NO. 71654



D3256-3 ACCESS PANEL

RELEASED
07-10-03

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK PER MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2)
OR MIL-G-12803A (GRADE P-1161A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3256	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ACCESS PANEL	1.2
DATE	07.09.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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